

Work Order ID 104705

\*104705\*

Page 1

July-17-13 7:36:46 AM

Item ID: D3137-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: GUIDE

Start Date: 7/17/13

Start Qty: 50.00

\*50\*

Cust Item ID:

Required Date: 7/24/13

Req'd Qty: 50.00

\*50\*

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3137

Rev F

100

0.00

\*100\*

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blanks.Blank size: 1.250" x .750" x .950" long

AT 13-07-20

x34

110

0.00

\*110\*

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA242 &amp; Dwg D31372-Deburr

DR/14 13/07/23

120

0.00

\*120\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

DR/14 13/07/23.

34

Work Order ID 104705

\*104705\*

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July-17-13 7:36:46 AM

Item ID: D3137-3 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: GUIDE  
 Start Date: 7/17/13 Start Qty: 50.00 \*50\* Cust Item ID:  
 Required Date: 7/24/13 Req'd Qty: 50.00 \*50\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 *130* QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		20 13.7.24		34	4		
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140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>8235A</u>  Memo	0.00  0.00				34			SP
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150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							13/7/29
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W 130726

# Picklist Print

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Work Order ID: 104705

Parent Item: D3137-3

Parent Item Name: GUIDE

Start Date: 7/17/13

Required Date: 7/24/13

Start Qty: 50.00

Required Qty: 50.00

## Comments:

IPP Rev:A02.05.29New IssueNG

IPP Rev:B 08-05-23 revE as per dwg DD verified by:EC

IPP Rev c 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MDELRLNB0.75X1.250

Purchased

No

100

f

3.8019

0.0791

4.1631579

Delrin Bar

## Location

## Loc Qty

## Loc Code

MAT018

3.801912

119133

0.008

120035

0.001476

123027

0.031736

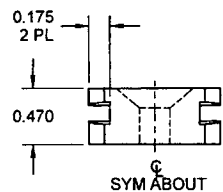
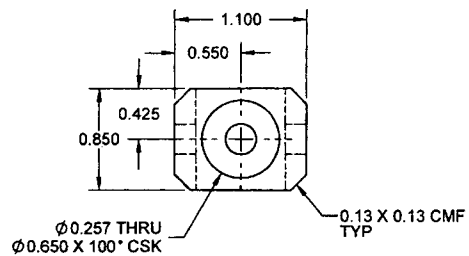
m126214

3.7607

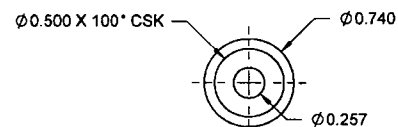
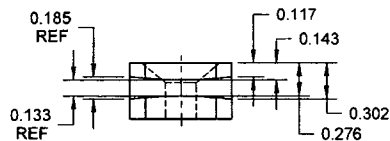
BT 13-07-20

x 3.7607

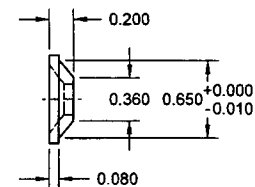




**D3137-3 GUIDE**



**D3137-5 WASHER**



**NOTES:**

- 1) MATERIAL: -3  
DELIN II 150E OR ACETRON GP ACETAL, BAR  
(REF DART SPEC M-DELIN-B)  
-5  
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR  
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)  
OR PER-QQ-A-200/8 (OR AMS 4160)  
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207  
-5 REPLACES PREMIER P/N B30-2300-209

**RELEASED**  
08.07.14

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	JAS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JAS	DRAWING NO.	REV. F
MFG. APPR.	JAS	D3137	SHEET 5 OF 5
APPROVED	JAS	TITLE	SCALE
DE APPR.	JAS	BRACKET ASSEMBLY	NTS
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